

Work Order ID 66241

February 8, 2011 8:44:07 AM



Page 1

Item ID: D3536-39

Accept



Setup Start



Revision ID:

Stop



Item Name: Gasket

Start Date: 2/08/11 Start Qty: 10.00



Cust Item ID:

Required Date: 2/22/11 Req'd Qty: 10.00

Customer:

Reference:

Run Start



Approvals: Process Plan: CL Date: 11/02/08 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3536	Rev A

100 0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3536 ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 2-
Deburr if necessary

B11-2-10



110 0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-2-10

120 0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8ul02/10

412

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66241

February 8, 2011 8:44:07 AM



Page 2

Item ID: D3536-39

Accept



Setup Start



Revision ID:

Stop



Item Name: Gasket

Start Date: 2/08/11

Start Qty: 10.00



Cust Item ID:

Required Date: 2/22/11

Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

0.00

Packaging

11/2/10 [Signature] (20)

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/02/11 [Signature]
mc
11-02-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February 8, 2011 8:44:07 AM

Page 1

Work Order ID: 66241

Parent Item: D3536-39

Parent Item Name: Gasket



Start Date: 2/08/11

Required Date: 2/22/11

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063 		Purchased	No			100	sf	177.5000	0.7534	8.371111	10.		
NEOPRENE SHEET 0.063													

Location

Loc Qty

Loc Code

MAT

177.5

115916

177.5

115916

(12)

11-2-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	66241
Description: Gasket		Part Number:	D3536-39
Inspection Dwg: D3536 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
35.71	+/-0.030	35.71	X		T 1801	
32.78	+/-0.030	32.78	X		T	
29.28	+/-0.030	29.28	X		T	
25.78	+/-0.030	25.78	X		T	
23.25	+/-0.030	23.25	X		T	
19.75	+/-0.030	19.75	X		T	
17.75	+/-0.030	17.75	X		T	
14.25	+/-0.030	14.25	X		T	
9.50	+/-0.030	9.50	X		T	
4.75	+/-0.030	4.75	X		T	
5.00	+/-0.030	5.00	X		T	
9.00	+/-0.030	9.00	X		T	
0.30	+/-0.030	.307	X		V 1802	
0.30	+/-0.030	.305	X		V	
1.88	+/-0.030	1.883	X		V	
Ø0.19	+0.005/-0.001	.190	X		V	
0.063	+/-0.010	.060	X		V	

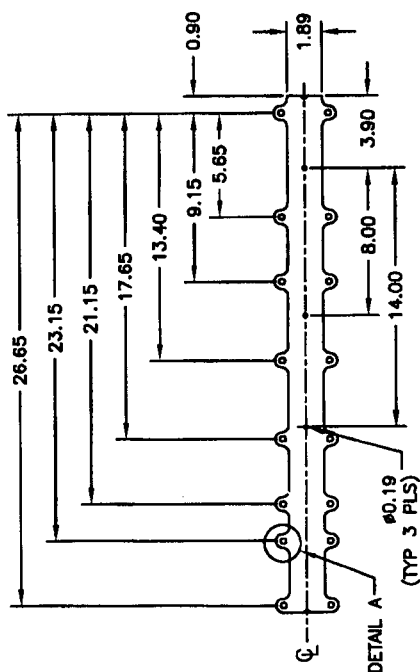
Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 11-2-10	Date: 11/02/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	[Signature]

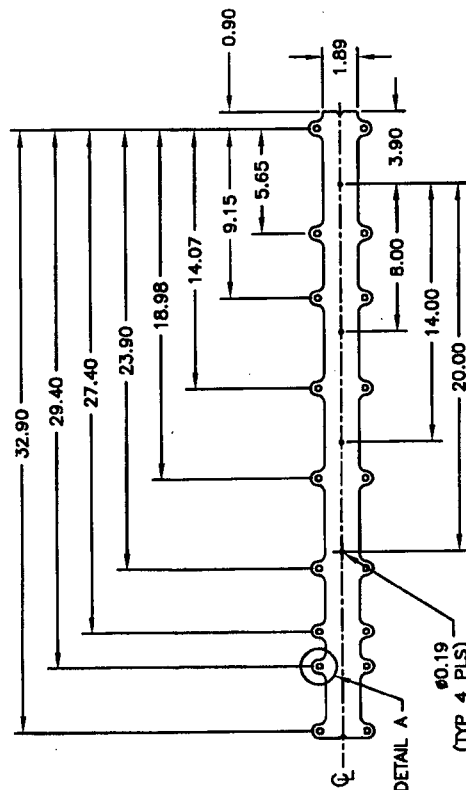
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DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED <i>[Signature]</i>	DRAWING NO. D3536	REV. A SHEET 1 OF 6
DATE 06.10.25		TITLE GASKET	SCALE 1:10
A	06.10.25	NEW ISSUE	

RELEASED

09.02.12 *[Signature]***D3536-11 GASKET**

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WORK ORDER
NO. 66241
CX1102108

**D3536-13 GASKET**

- NOTES**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.083)
 - 2) FINISH: NONE
 - 3) PART IS SYMMETRICAL ABOUT ϕ
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
 - 7) SEE PAGE 6 FOR DETAILS AND SECTION

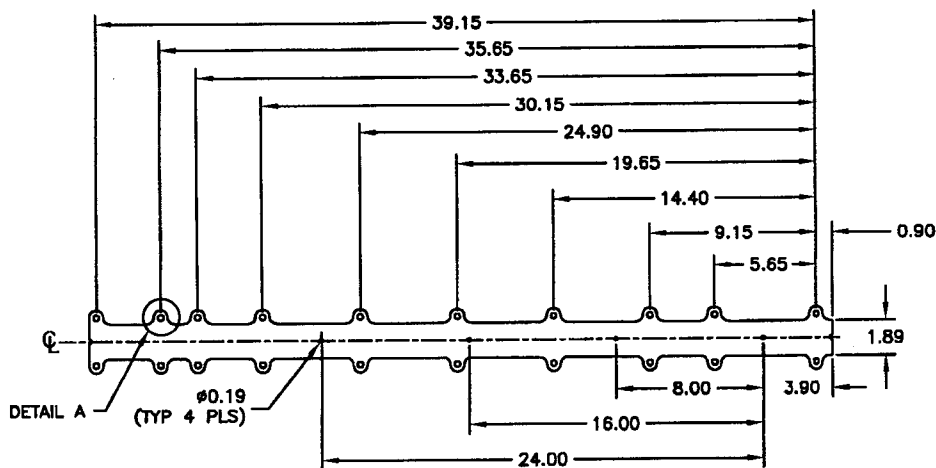
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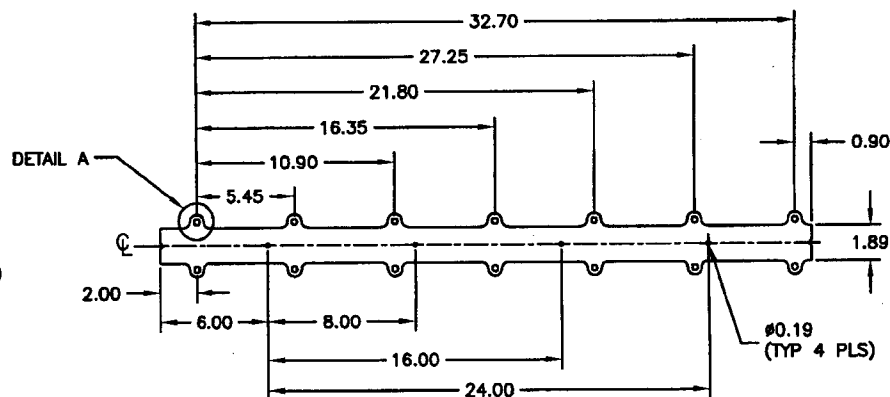


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				SHEET 2 OF 6
				SCALE
				1:10

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D3536-15 GASKET



D3536-21 GASKET

NOTES

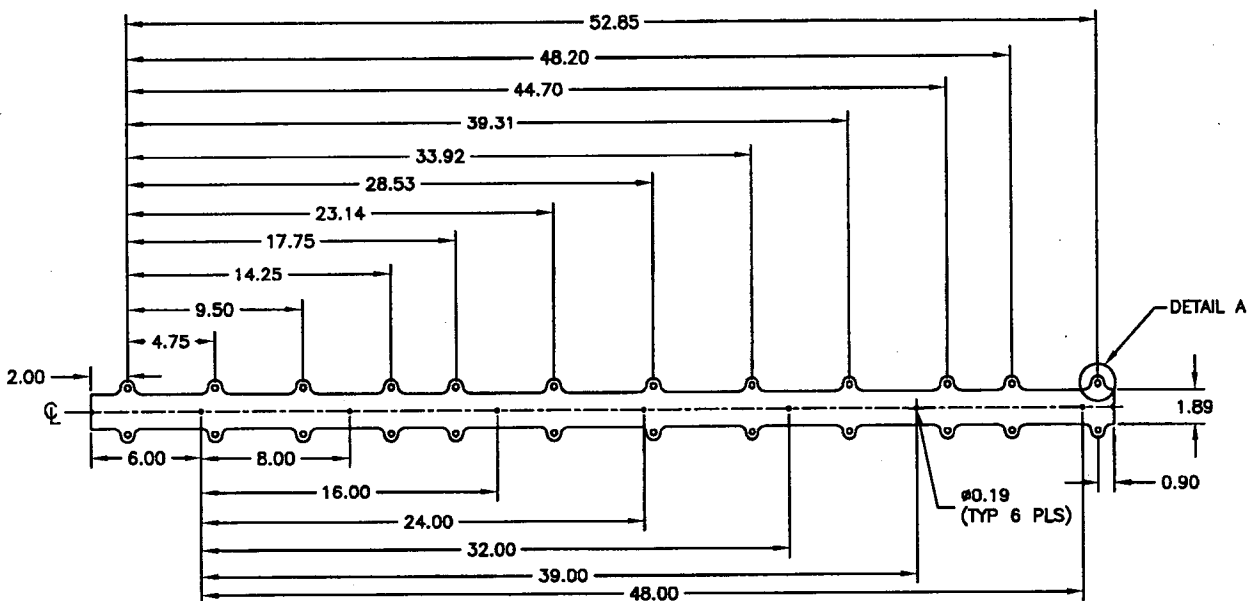
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- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
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DATE	06.10.25	TITLE	D3536	GASKET	SHEET 3 OF 6
		SCALE			1:10

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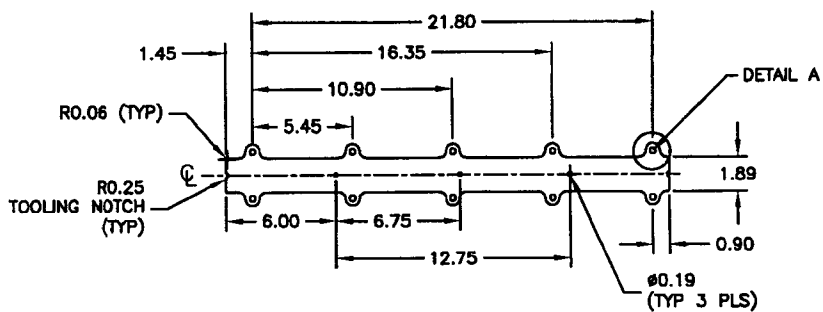


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NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
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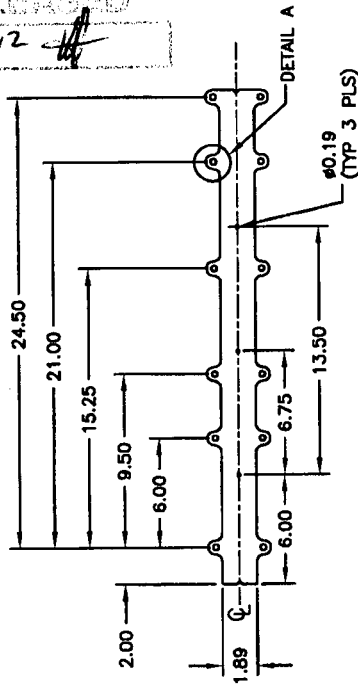
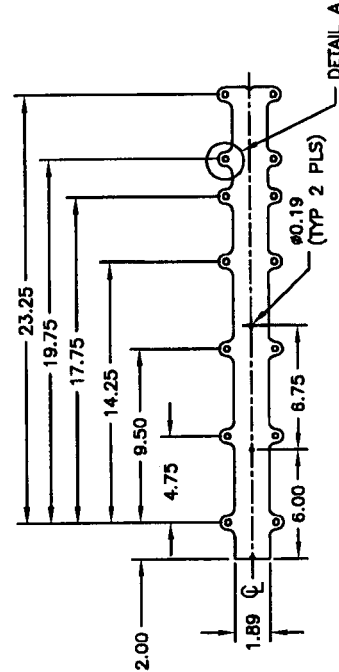
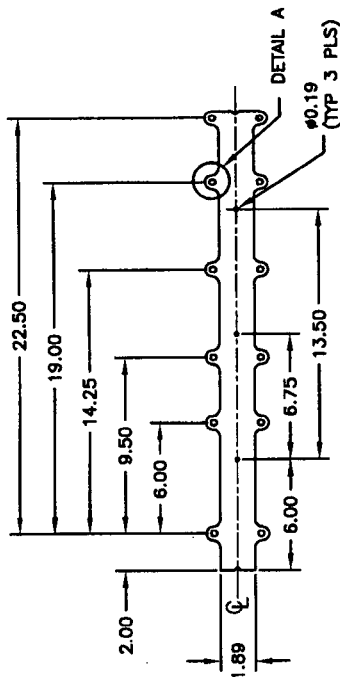
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**D3536-33 GASKET****D3536-35 GASKET****D3536-31 GASKET**

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- NOTES**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DURENOMETER (REF DART SPEC. M-NEO60-S.063)
 - 2) FINISH: NONE
 - 3) PART IS SYMMETRICAL ABOUT C
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
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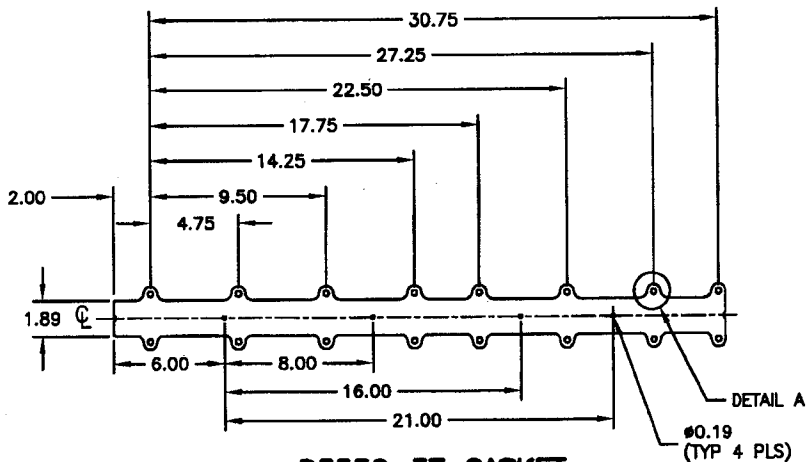
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		TITLE	GASKET	SHEET 5 OF 6
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03.02.02

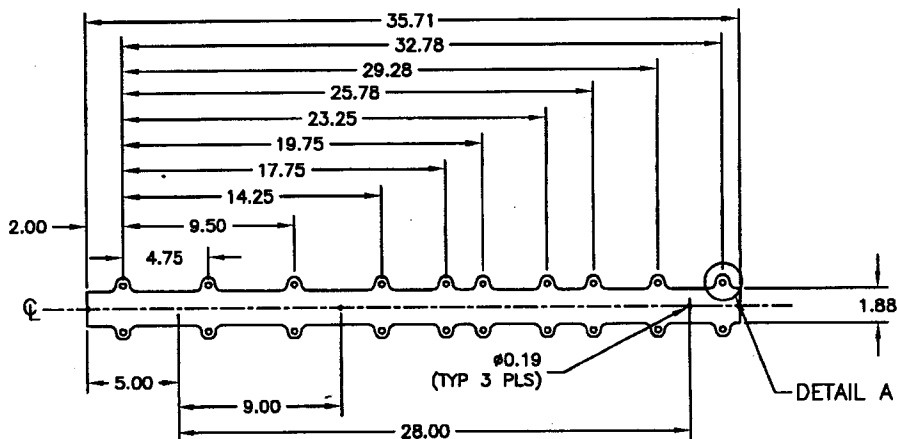


D3536-37 GASKET

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NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE080-S.063)
- 2) FINISH: NONE
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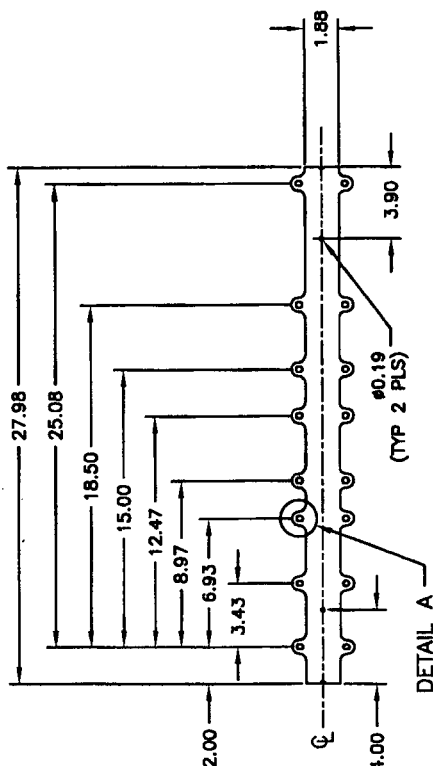
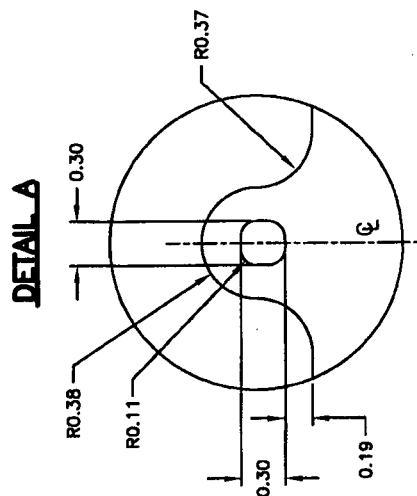


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- NOTES**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
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